

WORK INSTRUCTION

Title: **Minor Repair of ICV/OCV Locking Ring Surfaces (burrs, dings, and nicks)**

Instruction No. CH.14

Rev. 0, January 2002

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Approved for Use by: Michael R. Brown Effective Date: January 2002

Applicable Drawings:

- 2077-500SNP (Sheet 8) - TRUPACT-II Packaging SARP Drawings
- 707-SAR (Sheet 10) - HalfPACT Packaging SARP Drawings

SARP Requirements:

- Chapter 8.0, Section 8.2.3.2. As required.

Tools Required:

- Lifting Equipment
- Lid Stands

Spare Parts Required:

- None

Materials Required:

- Unused 400 to 600 Grit Emery Cloth
- Denatured Alcohol or equivalent
- Lint-Free Rags

Safety Requirements:

- Safety will be observed in accordance with site requirements.

Prerequisite Conditions:

- ICV/OCV lid(s) must be removed to gain access to locking lug surfaces.

Instruction Steps:

- This instruction **is not required to be attached** to the Maintenance Record but may be used as a checklist during performance of maintenance.

☐ ICV or OCV Locking ring lug(s)

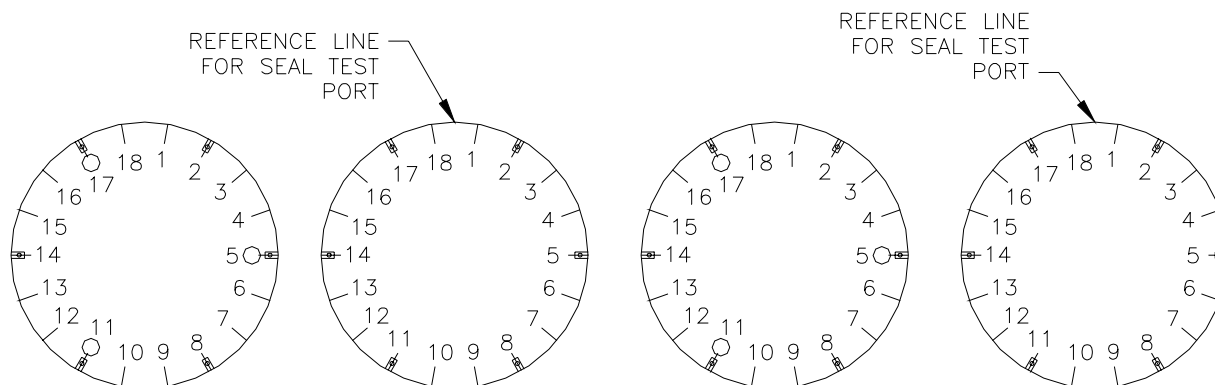
- 1.0 Using alcohol and lint-free rags, thoroughly clean area to be repaired.
- 2.0 Using emery cloth, remove any burrs and restore lug to original profile.
- 3.0 For larger burrs, use a fine cut file, then Emory cloth to remove file scratches and restore surface to 125 micro-inch finish or better.
- 4.0 Clean repaired area to remove any residue.
- 5.0 Using Work Instruction CH.14, Form 1, record locations where repairs were made.

Verification Requirements:

- 1.0 Work performed is described on maintenance record.
- 2.0 Work instruction is listed on maintenance record.
- 3.0 Data sheet (Work Instruction CH.14, Form 1) is attached to maintenance record.

Attachment 1, Form 1 - ICV/OCV Lid and Body Locking Ring Surfaces

Packaging S/N: _____ Date: _____ Job. No. _____



ICV LID		ICV BODY		OCV LID		OCV BODY	
Loc.	✓*	Loc.	✓*	Loc.	✓*	Loc.	✓*
1.		1.		1.		1.	
2.		2.		2.		2.	
3.		3.		3.		3.	
4.		4.		4.		4.	
5.		5.		5.		5.	
6.		6.		6.		6.	
7.		7.		7.		7.	
8.		8.		8.		8.	
9.		9.		9.		9.	
10.		10.		10.		10.	
11.		11.		11.		11.	
12.		12.		12.		12.	
13.		13.		13.		13.	
14.		14.		14.		14.	
15.		15.		15.		15.	
16.		16.		16.		16.	
17.		17.		17.		17.	
18.		18.		18.		18.	

* Deficiencies/adjustments noted on Maintenance Record

QA: _____ Date: _____

Other: _____ Date: _____